

Date: Tuesday, 8/1/2006 11:29:32 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 28062A	Part Number	: D23243
Estimate Number	: 10731	Drawing Number	: D2324 REV. C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 8/1/2006	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 8/18/2006
Previous Run	: 27050A	Qty:	20
Written By	: <u>JL 06-08-01</u>		
Checked & Approved By			
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"	
Comment: Qty.: 0.5565 f(s)/Unit Total : 11.1300 f(s) 6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8) (M6061T6B0.750x00.750) Batch: <u>ML 06/08/19</u> <u>20</u>			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar <u>ML 06/08/19</u> <u>20</u>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges Identify as D2324-3 <u>ML 06/08/20</u> <u>20</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ML 06/08/20</u> <u>20</u>			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <u>JL 06/08/20</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: Date: 06/08/27

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.m

06-08-23

20

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

sh

06/08/23

20

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST37

sh 06/08/23

20

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

sh 06.08.21

Job Completion



U 26.08.23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

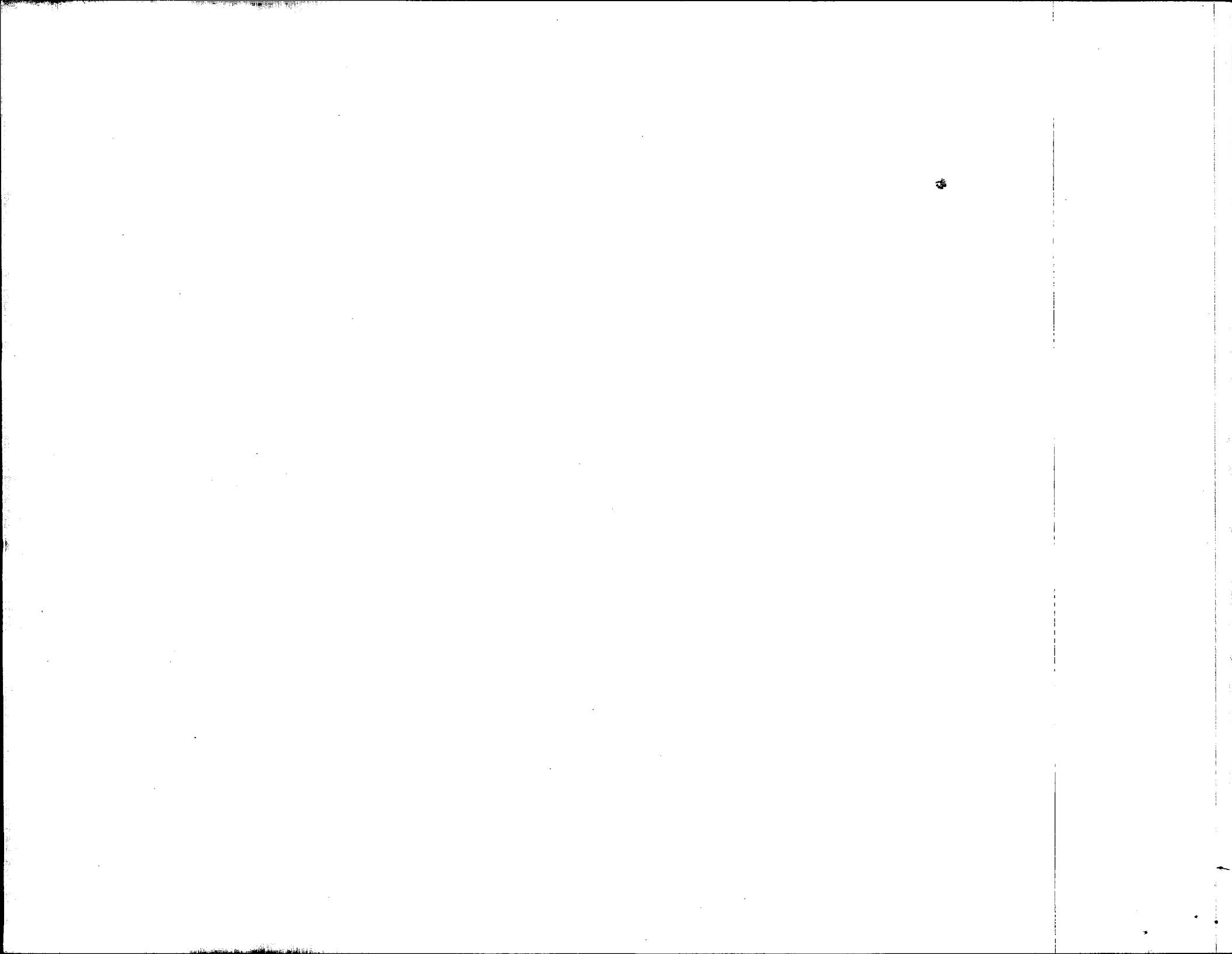
DART AEROSPACE LTD	Work Order:	28062A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JNL</u>	Audited by:	<u>EP</u>	Prototype Approval:	N/A
Date:	06/08/19	Date:	06/08/19	Date:	N/A

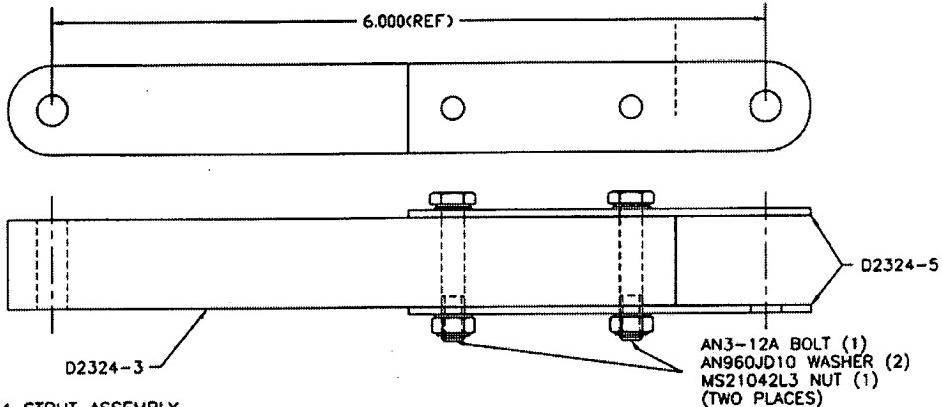
Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue P/O D2324-1	KJ/JLM	
B	06.03.08	Dwg Rev changed	KJ/JLM	



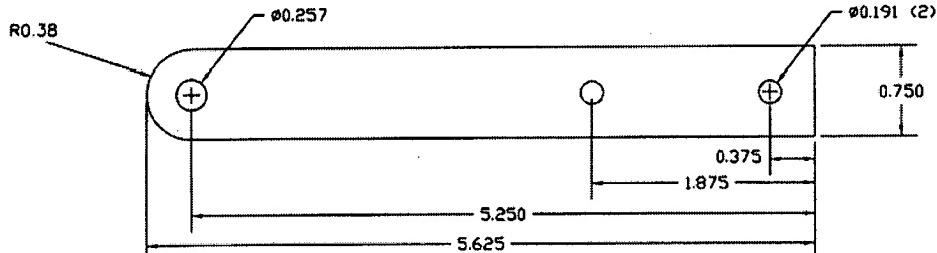
DART

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324 REV. C
DATE 04.12.14		SHEET 1 OF 1
		TITLE STRUT
A	94.11.08	SCALE NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

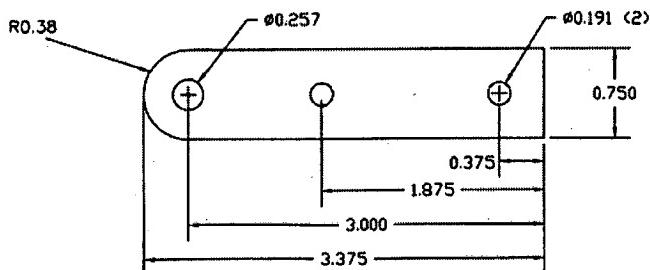
RELEASED

04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651-BAR-(QQ-A-200/8)-0.75-X-0.75
(REF DART SPEC. M6061T6B0.75X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *Z8062 A*